

Work Order ID 135416

Wednesday, August 12, 2015 4:27:40 PM

135416

Page 1

Item ID: D2586 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Latch
 Start Date: 8/12/15 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: WJ Date: AUG 13 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2586	Rev E								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 29484
 Possible Supplier: Southco, P/N: C2-32-25 TCH Sales
 Certification Required

CY AUG 17 2015 15

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging 1-Attach certification
 2-Keep Key with latch

15x 8/15-08-19

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

(15) DAS
38
9-89
AUG 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 2

Wednesday, August 12, 2015 4:27:40 PM

Item ID: D2586 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Latch
 Start Date: 8/12/15 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.01							
Small Fab	1-Drill Hole to 0.191"								
	2-Counterface as per Dwg D2586								
	3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>sl 482</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	***Ensure key is bag with latch***								

15 FF AUG 31 2015
 (15) DAS 38 9-89
 AUG 31 2015
 B 27 9-89
 AUG 31 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 135416

135416

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Wednesday, August 12, 2015 4:27:40 PM

Item ID: D2586 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Door Latch Stop *NS2*

Start Date: 8/12/15 Start Qty: 15.00 *15* Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 15.00 *15* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

SH 120150831

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing, ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 1

Wednesday, August 12, 2015 4:27:39 PM

Work Order ID: 135416

135416

Parent Item: D2586

D2586

Parent Item Name: Door Latch

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP E02.01.31 Added Inspect level 21NG IPP RevF: add not to keep key with latch DD 10.02.10 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
C23225		Purchased	No			110	Each	0.0000	1	15			
C23225									**				
DOOR LATCH													
D3015-7		Manufactured	No			130	Each	10.0000	1	15			
D3015-7									**				
Lock Nut													

15-08-19
FF AUG 31 2015

Location

ST015

128856

Loc Qty

10

10

Loc Code

* M1347C3

10
5

DQA: _____ Date: _____



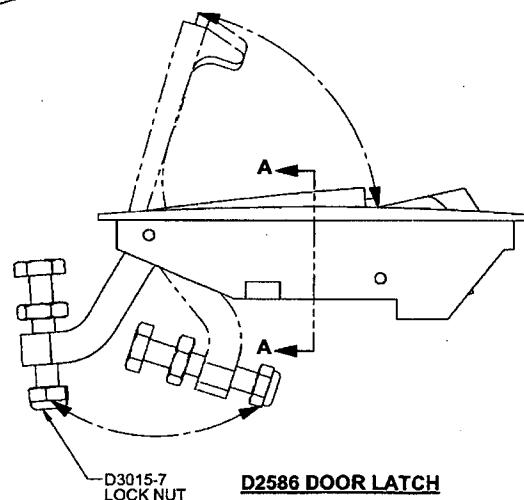
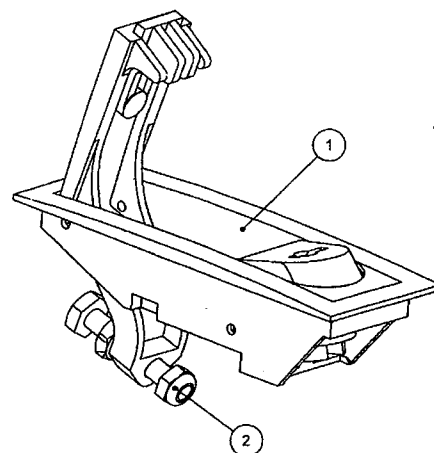
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

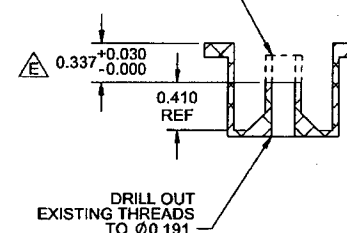
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
	X	D2586	LATCH ASSEMBLY
1	1	C2-32-25	LATCH
2	1	D3015-7	LOCK NUT



REMOVE CBORE TOP TO
REMOVE MATERIAL FROM
EXISTING BOSS



SECTION A-A

RELEASED
2011-07-04

NOTES:

- 1) MATERIAL: PURCHASE FROM SOUTHCO
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs APPROX

E	REFORMAT: ZONE B3 UPDATED DIMENSIONS FOR CBORE. (SEE CAR 11-32)	AJS	11.08.13
D	ADD 3015-7 P/N; UPDATE DRAWING	CB	06.10.19
C	REVISED C'BORE DEPTH	KE	07.09.03
B	CHANGED C'BORE DEPTH	KE	07.07.23
A	NEW ISSUE	KE	06.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2586	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH	NTS
DATE	11.06.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29484**

Purchase Order Date 8/17/2015

PO Print Date 8/17/2015

Page Number 1 of 2

Order From :

VC-TCH001

Ship To : DART AEROSPACE LTD

TCH SALES INC.
C/O TH1212
PO BOX 4290 STN A
TORONTO, ON M5W 0E1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 416 299 0089

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Terms

Net 30

Ship Via:

FedEx Intl Economy

Currency

CAD

Ship Acct:

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	C23225 AS PER DWG D2586 REV. E B135416	DOOR LATCH	8/21/2015 Yes 8/21/2015		15.00 Each	\$18.50	\$277.50
						Line Total:	\$277.50
2	71401-45	PROCUREMENT QUALITY CLAUSES	8/21/2015 No 8/21/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A026 certification of material conformance A040 notification of quality escape A041 quality management system A042 dart notification be sypplier A043 retention of quality documents							

Note:

8/17/2015

T.C.H. Sales Inc.
 40 Emblem Court
 Toronto, Ontario M1S 1B1
 Phone: 1-800-465-6281
 Fax : 1-855-299-3214



PACKING SLIP

VENDOR #	
DUNS #	242445328
TAX #	R105150197

143407

CUSTOMER NUMERO DU CLIENT	STORE NUMBER NUMERO MARCHE	DEPARTMENT DIVISION	CUSTOMER PO COMMANDE DU CLIENT	ORDER COMMANDE	PACK NUMBER BON DE LIVRAISON	BOL NUMBER BOL NUMBER	PICK # NUMERO PICK	A/R TERMS A/R TERMES	PAGE PAGE
22428			29484	145489	171526		191749	30	1

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A
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

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DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CAN

TEL: 613-632-9577

SHIP TERM CODE DE TRANSIT	SHIP VIA TRANSITAIRE	TRACER NUMERO DE TRACER	PACK DATE DATE DE PACK	CANCEL DATE DATE DE CANCEL	PCS PCS	WEIGHT POIDS	MEMO MESSAGES DIVERS
COLL	FedEx Priority	7210 2347 4104	08/18/15	12/31/16	1	8	email/ chantal type 1

PRODUCT CODE CODE DU PRODUIT	DESCRIPTION DESCRIPTION	ORDERED COMMANDEE	SHIPPED EXPIDIEE	BACK ORDERED NON EXPIDIEE
C23225	BLK LEV LATCH RAISED TRIG W/LK C2-32-25 DOOR LATCH	15	15	0
		15	15	0

SP15-08-18

Visit Us Online

www.tchweb.com

Conditions Of Sale:

All shipments FOB Scarborough, Ontario.
 All returns are subject to a 15% handling charge and must be authorized.
 All claims and discrepancies must be reported within 7 days.
 We have the right to charge collection and attorney's fees of 25% and interest of 2% per month (or 24% per annum) on all overdue accounts.

Conditions De Vente:

Tous les retours de marchandises sont soumis a des frais de manutention de 15% et a l'autorisation.
 Veuillez signaler toutes les anomalies ou irregularites dans les sept jours.
 Nous avons le droit d'imposer dans frais de recouvrement et de procedure de 25%, ainsi qu'un interet de 2% par mois (ou 24% par an) sur tous les comptes en souffrance.
 Les biens faisant l'objet de la presente facture demeurent la propriete du vendeur jusqu'a parfait paiement.